

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021784**Date Inspected:** 14-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 12CW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated CA3010C-281, Corner Assembly Diaphragm stiffener at panel point 115.2. The welder is identified as #046709 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-P-2113-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated CA3010C-238, Corner Assembly Diaphragm stiffener at panel point 115.2. The welder is identified as #046709 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated CA3010C-280, Corner Assembly flange at panel point 115.2. The welder is identified as

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## WELDING INSPECTION REPORT

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#046709 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated CA3010C-279, Corner Assembly stiffener at panel point 115.2. The welder is identified as #046709 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspector is identified as Zhou Peng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 12BE/12CE

This QA Inspector observed match drilling of bolt holes in the Longitudinal Diaphragm for the bolt splice plate connection, cross beam and bike path side.

Segment 12CW

This QA Inspector observed tightening of high strength bolts on the Bottom Plate WT stiffener splice plate between panel points 116-116.5 using a pneumatic impact wrench.

Bay 14

This QA Inspector observed Welder Qualification using the Shield Metal Arc Welding (SMAW) process for Groove Weld Qualification (Complete Joint Penetration) for plate of unlimited thickness in the 3G (vertical) and 4G (overhead) positions.

Position, Process, WPS, welder ID# and name are as follows:

3G

SMAW

WPS-B-P-2213-B-U2a-1

501946 Yang Jun Ping

4G

SMAW

WPS-B-P-2214-B-U2a-1

051359 Bian Heng Gui

058087 Chen Ren Zhi

216086 Wang Zhen Bin

044760 Chen Chun Lin

204339 Zhu Ming Song

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# WELDING INSPECTION REPORT

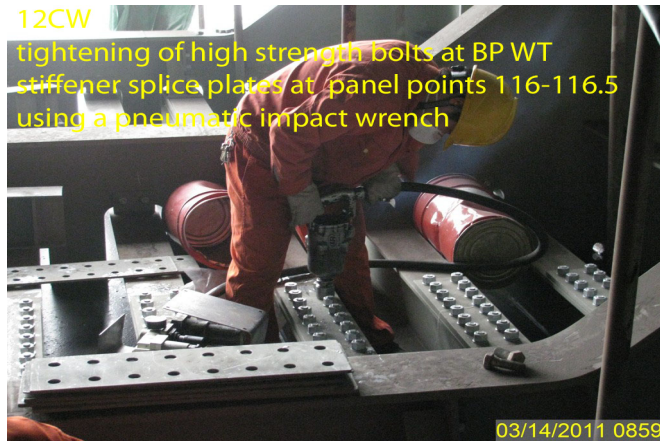
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215553 Yang Yun Feng  
050969 Gua Tao Tao  
050232 Yin Xiao Kai

ZPMC CWI Li Yan Hua was present during welder qualification

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

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**Inspected By:** Hernandez,Dan

Quality Assurance Inspector

**Reviewed By:** Miller,Mark

QA Reviewer

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